

Work Order ID 59255

Friday, May 28, 2010 9:10:22 AM



Page 1

Item ID: D3147-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pin

Start Date: 5/28/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *RP*

Date: *10-5-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3147	Rev C								

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA691 & DWG D3147, □FOLIO
REV: □DWG REV: *C* □2-DEBURR AS REQUIRED

SL 10/06/27 *(10)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/06/27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 10/06/28

10

/

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 036

0.00



Packaging

Memo

0.00

Packaging

10/06/28 (10)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 J

ME 10-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, May 28, 2010 9:10:27 AM

Page 1

Work Order ID: 59255



Parent Item: D3147-1



Parent Item Name: Pin

Start Date: 5/28/2010

Required Date: 6/4/2010

Comments: IPP Rev A New Issue 07-01-26 JLM
 IPP Rev:B Now on Cnc 07-05-02 JLM
 IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304TS0.750W.065		Purchased	No				f	1,116.480		5.8			



304 SQ Tube .75x.75x.065W

M303R0.187

Round bar

10.06.01

Location	Loc Qty	Loc Code
MAT	116.48021	
112398	0	
114482	116.48021	
WA	1000	
114520	1000	

114968

2.2 JL 10/06/27

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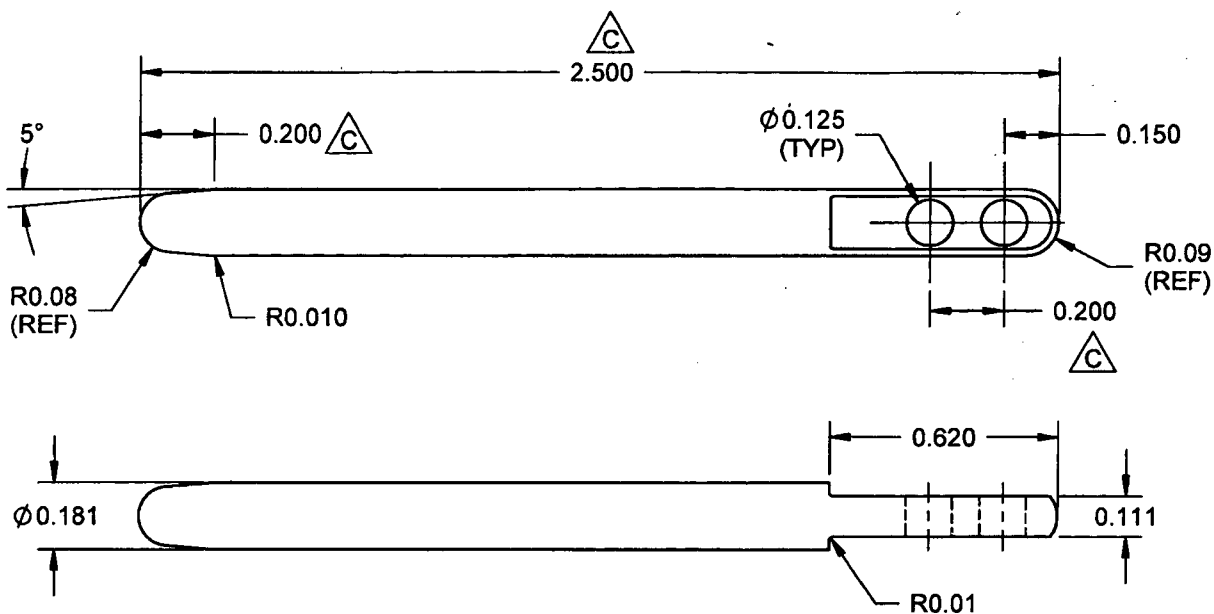
Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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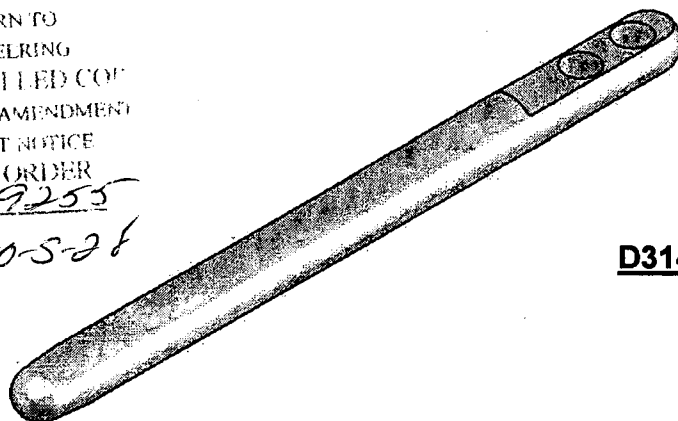
NOTE: Date & initial all entries



DESIGN #	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED JH	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND Ø0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59255



D3147-1 PIN

RELEASED

07.01.22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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